



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-3-6

Job Sheet 171688



Part No: C45-3-6

Job Qty: 10 ea

Part Name: Latch



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: C45-3-6 rev.10 IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/8/18	0.00	0.00	Start Up Machining-4		18/02/14
100	Bandsaw	10 pcs		2/8/18	0.00	0.50	Bandsaw1		18/02/14
120	CNC Vertical Machining	10 pcs		2/9/18	0.50	5.00	MORI NV5000-1		18/02/14
130	QC	10 pcs		2/9/18	0.00	0.00	QC2 Machining-5		18/02/14
140	QC	10 pcs		2/9/18	0.00	0.00	QC8 Machining-5		18-07-19
150	Packaging	10 pcs		2/9/18	0.00	0.00	Packaging3-2		FEB 21 2018
160	QC21-FG	10 Ea		2/9/18	0.00	0.00	QC21		FEB 21 2018

Part Op 100 - CUT BLANK AT 1.325"

Descriptions: 120 - 1-Machine as per folio FB814 FOLIO REV: DWG REV: 2-Debur

150 - Identify and Stock

130- ENGRAVE BATCH NUMBER USING MARKTRONIC ENGRAVER AS PER DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.000X02.000	17-4 SS Bar 1.00 x 2.00	1.6666 ft (.16666 ea)	100-Bandsaw	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw	M17-4-B1.000X02.000	2	0	0

Part Specifications

Specifications could not be found.

5030457 + 5042871

1.500

Plex 2/7/18 11:54 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
			Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
			Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
			Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation

 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-8200 Email: sales@dartaero.com www.dartaerospace.com		Date: 02/20/18

Root Cause		Pressure/Force		Wrong dimensions or tolerance	
Environment ☐	No Re-verification ☐	Bending ☐	Centre Not Cor ☐	Cracks ☐	Crimp/Kink/Rip ☐
Design ☐	Operator ☐	Cracks ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐
Doc/Data ☐	Offset/Setup ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐
Equip/Tooling ☐	Supplier ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	OTHER : ☐	
Handling/Pre ☐	Training ☐	OTHER : ☐			
Material ☐	Use for Testing ☐				
Internal Transport ☐	Poor Information ☐				
Tribal Knowledge ☐	Rushing ☐				
LOA ☐	Product Improvement ☐				
Substation ☐	Process Improvement ☐				
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD		Work Order: 171688
Description: LATCH		Part Number: C45-3-6
Inspection Dwg: C453-6 Rev: 10		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.78	±.010	1.780	—		Vern HL-08	
.715	±.005	.712	—		"	
.375	±.005	.374	—		"	
.170	±.005	.166	—		"	
.450	±.005	.450	—		"	
.38	±.000	.383	—		"	
.30	±.010	.300	—		"	
63°	±1/2°	63°	—		C-Square	
.766	±.005	.766	—		Vern HL-08	
1.05	±.000	1.050	—		"	
.26	±.010	.260	—		"	
.115	±.005	.115	—		"	
44°	±1/2°	44°	—		C-Square	
14°	±1/2°	14°	—		"	
1.33	±.010	1.329	—		Vern HL-08	
.920	±.005	.918	—		"	
.44	±.010	.442	—		"	
20°	±1/2°	20°	—		C-Square	
1.50	±.010	1.500	—		Vern HL-08	
.480	±.005	.480	—		"	
.468	±.000	.4678	—		"	
.188	±.005	.187	—		"	
.140	±.005	.139	—		"	
.124	±.005	.124	—		"	
Ø.191	±.005	Ø.196	—		"	
Ø.376	±.000	Ø.377	—		"	
Ø.625	±.005	Ø.625	—		"	
.048	±.005	.050	—		"	
Ø.566	±.001	Ø.566	—		"	

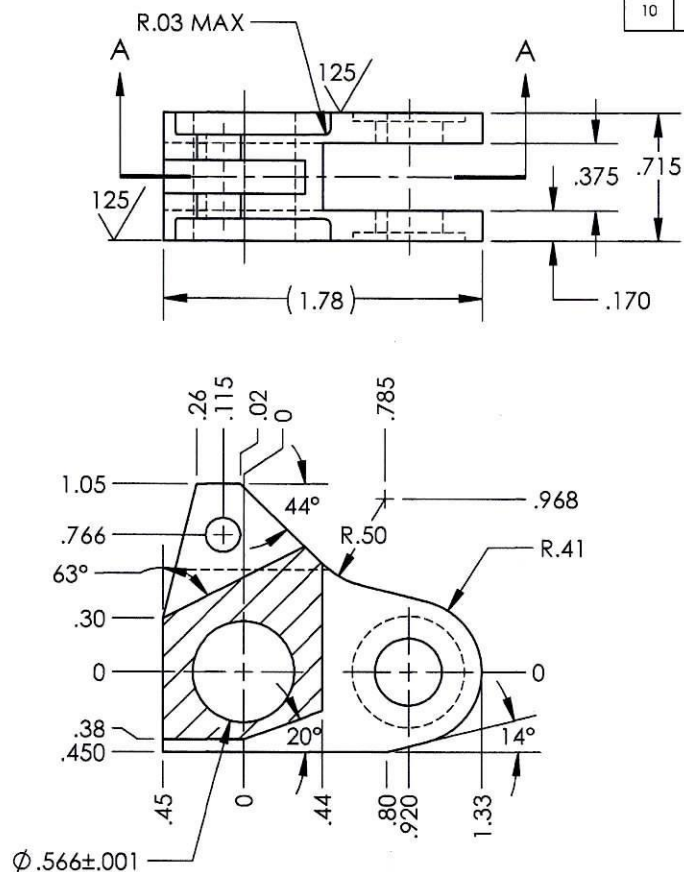
Measured by: <i>mf</i>	Checked by: <i>Ln</i>	QC Inspector:
Date: 18/02/14	Date: 18-02-19	Date:

Engineering Approval: (If necessary)	Date:
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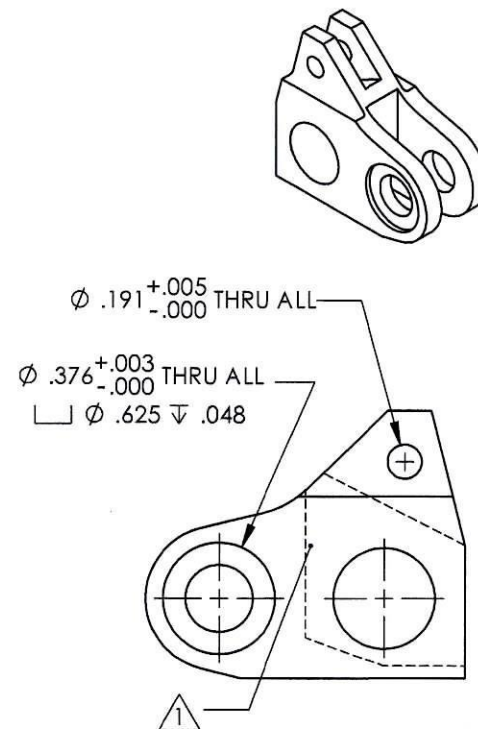
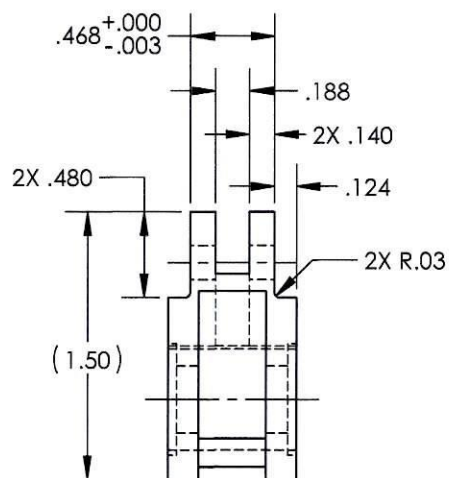
Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8		AS DRAWN BY CANAM.	9/11/2012	RJC	
9		CH'D Ø.564 TO Ø.566 & Ø.189 TO Ø.191	10/30/2012	JAG	
10	14-0126	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/13/2014	DPD	RW



SECTION A-A



NOTE:

① MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE LATCH	
DWG NO. C45-3-6	REV 10
MAT'L 17-4 SS	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .006	REACT
.XX ± .01	TREAT
.X ± .1	FINISH
ANGLES ± .6°	SPEC
1. BREAK ALL SHARP EDGES .016 x 45° OR .016R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 5/14/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-3-6	1	LATCH	17-4 SS	3/4 X 1-1/2 X 2